

Date: Wednesday, 09/04/2008 9:18:32 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 38506
 Estimate Number : 13099
 P.O. Number :
 This Issue : 09/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : THERMOFORMING
 Previous Run : 37666
 Written By :
 Checked & Approved By : JD 08.4.09
 Comment : Est. Rev. A 07/12/13 DL verified by:DD

Drawing Name : PANEL-350 FWD CANOPY
 Part Number : D36563
 Drawing Number : D3656 REV A
 Project Number : 00204
 Drawing Revision : A
 Material :
 Due Date : 30/04/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 MLEXS093F600607 GE PLASTICS LEXAN SHEET



Comment: Qty.: 23.0000 sf(s)/Unit Total: 46.0000 sf(s)

GE PLASTICS LEXAN SHEET

batch: M107574

PTD.
 X6 → PTD.

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 08/09/10 X6

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

X6 -

Dwg. Rev. A

Folio Rev. A

BB 08/09/10 X6

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

X6 - PTD.
 BB 08/09/10 (X6)



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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



08/04/11
DH
x2

Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



08/04/11
DH
x2

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



08/04/11
DH
x2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



08/04/11 (x2)

Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 39387

08/05/11 (1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/11
DH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/05/11

DART AEROSPACE LTD	WORK ORDER: 38506
Description: PANEL 350 FWD CANOPY	Part Number: D36563
Inspection Dwg: D3656 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Tight, even radius throughout part	DL
Acceptable shape definition	DL
Acceptable texture retention	DL
Free of visual flaws (bumps, cracks, voids, etc.)	DL

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D36563 Rev. A and record below

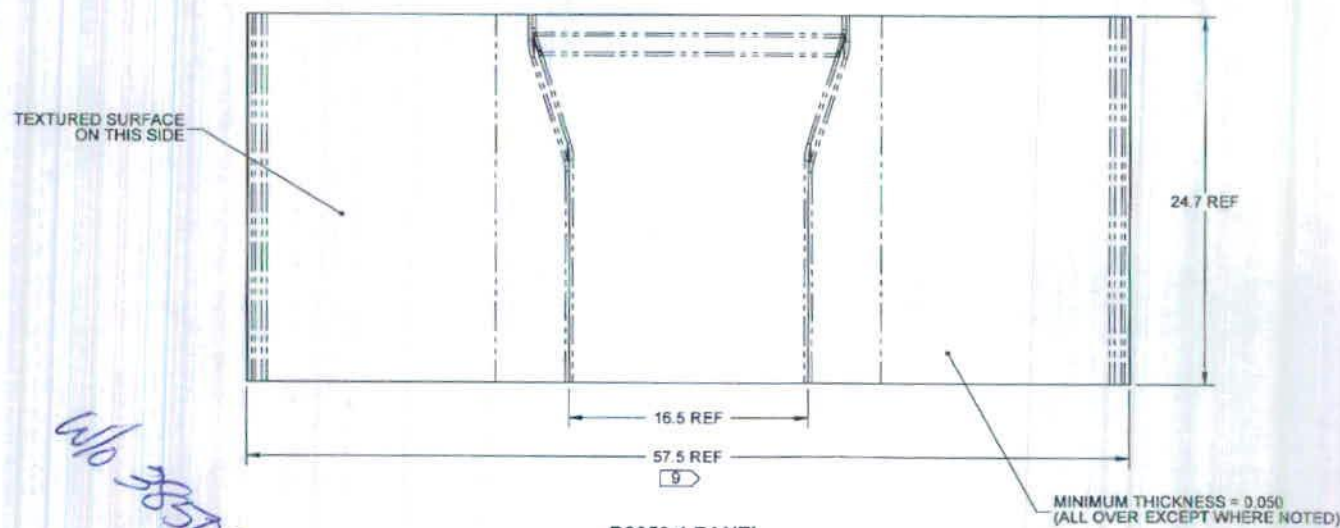
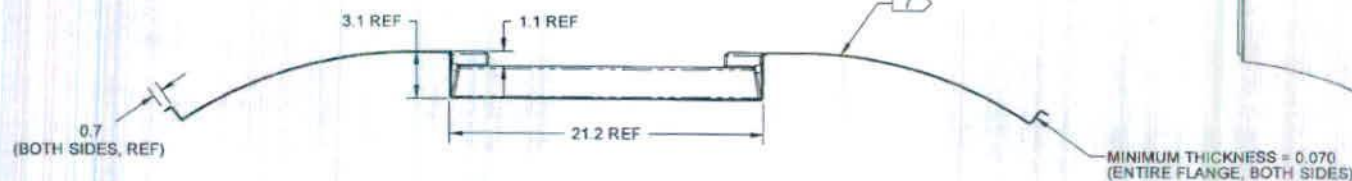
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40.75	.1	40.75	✓		tap	
60.25	.1	60.25	✓		tap	
0.045	.002	0.058	✓		vern	
0.050	min	0.053	✓		mic	

Measured by: DL	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 02-04-10	Date: 02-04-10	Date: 02-04-10

Rev	Date	Change	Revised by	Approved
		New Issue		

[Signature]





D3656-1 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY58133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER MOLD DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

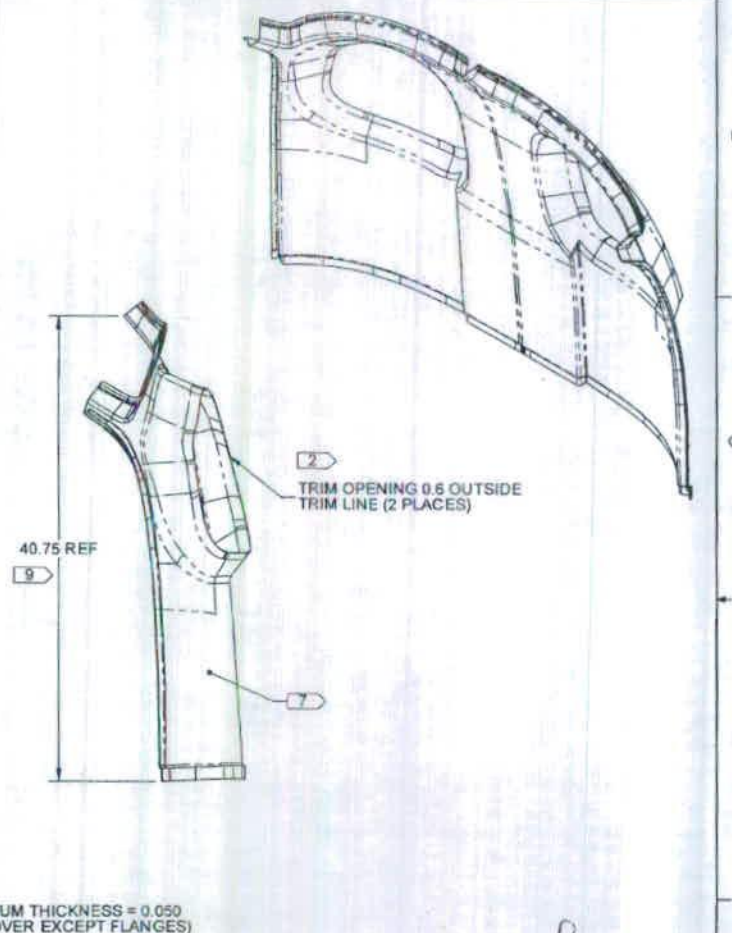
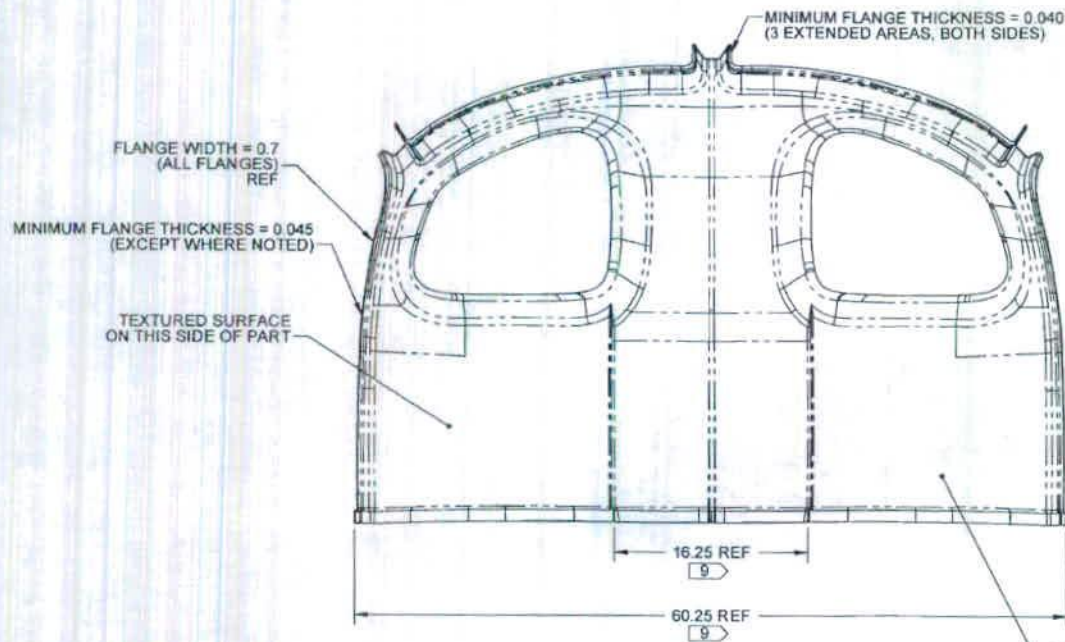
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	LE	08.03.03
DESIGN	LE		
DRAWN	LE		
CHECKED	RE		
MFG. APPR	MP		
APPROVED	MP		
DE APPR	MP		
DATE	08.03.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3656** REV. A
SHEET 1 OF 2
TITLE **PANEL** SCALE NTS

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D3656-3 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY58133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022
TRIM PER MOLD DT8987 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO	REV. A
MFG. APPR.	RE	D3656	SHEET 2 OF 2
APPROVED	WJP	TITLE	SCALE
DE APPR.	WJP	PANEL	NTS
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